

Work Order ID 70965



Page 1

Monday, June 20, 2011 12:38:24 PM

Item ID: D2576-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Step (casting detail)

Start Date: 6/20/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/06/20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2576

Rev G

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 14320 ☐ Ship D2576 mould to vendor ☐ Cast per D2576-1
Pattern vendor: Alpine Non- Ferrous ☐ Material Release Note Required

CL 11/06/20 50

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure D2576 mould is returned with the ordered parts ☐ Ensure release note is attached

11/7/8 (50)

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8/11/11

10/11/11 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70965



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Monday, June 20, 2011 12:38:24 PM

Item ID: D2576-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Step (casting detail)

Start Date: 6/20/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 50.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <u>MAT</u>	0.00							
Packaging Packaging	Memo	0.00				50	0		
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

11/7/11
MF
11-07-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 20, 2011 12:38:22 PM

Page 1

Work Order ID: 70965

Parent Item: D2576-1

Parent Item Name: Step (casting detail)





Start Date: 6/20/2011

Required Date: 6/30/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev: A New Issue 05-11-29 JLM
IPP rev B rev F dwg 07.07.06 EC
IPP Rev:C As per Rev G 07-09-05 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2576-1P  Step (Casting Detail)		Purchased	No					100	Each	0.0000	1 	50	

[Handwritten Signature]

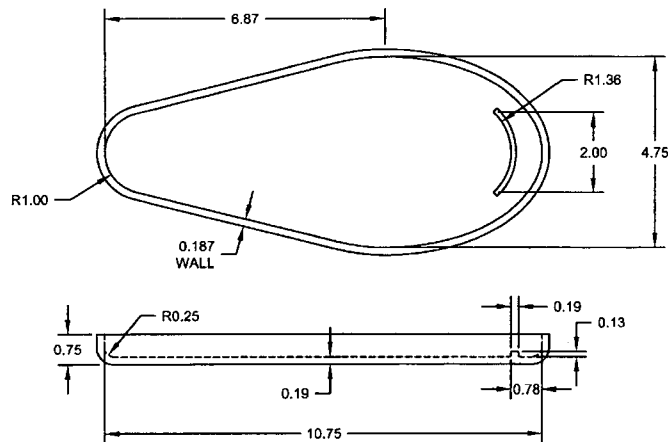
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

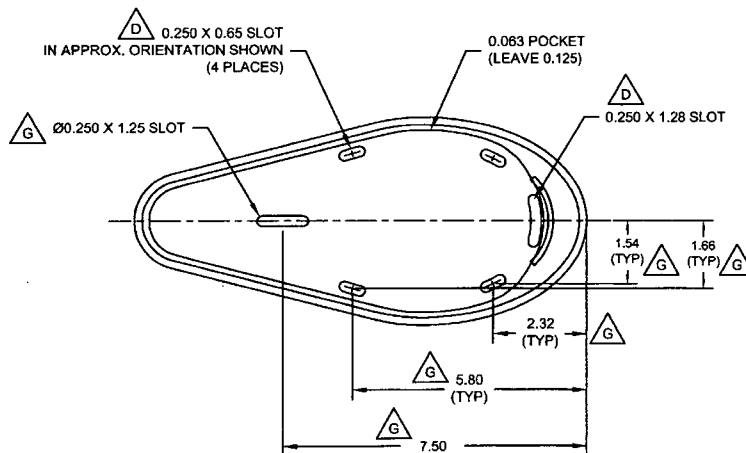
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2576-1 CASTING



D2576-3 MACHINING DETAIL
(MAKE FROM D2576-1)

NOTES:

- 1) MATERIAL: CAST ALUMINUM ALLOY A-535.2
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.025 TO 0.050 MAX
- 6) IDENTIFICATION: NONE

211106120
W10.7065

RELEASED

07.08.21

REV.	DESCRIPTION	BY	DATE
G	- CHANGE SLOTS LOCATION AND SIZE ON D2576-3 - DUE TO SKID BENDING PROGRAM CHANGES - UPDATE CNC PROGRAM	MB	07.08.15
F	7.05 WAS 6.61	PH	07.04.17
E	CHANGE 0.50 HOLE LOCATION AND ADD NOTE	RF	99.09.07
D	CHANGE SLOT SIZE AND LOCATION (TSR A1069)	CP	99.08.18
C	ADD POCKETS AND SLOTS FOR WELDING	DS	98.08.18
B	REMOVE POCKETS, ADD HOLE	DS	96.11.28
A	NEW ISSUE	DS	96.09.18
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2576 TITLE STEP SCALE 1:3 COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.08.15		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO14320

Purchase Order Date 6/20/2011

PO Print Date 6/20/2011

Page Number 1 of 1

Order From :

VC-ALP001

ALPINE NON-FERROUS FOUNDRY
8657 - 132ND STREET
SURREY, BC V3W 4P1
CA

Contact Name

Vendor Phone

604 596 8080

Vendor Fax

604 596 8045

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
6/21/2011

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2576-1P	Step (Casting Detail)	6/30/2011 Yes	50.00 Each	FedEx PI collect	\$17.7500	\$887.50

Special Inst: AS PER DWG D2576 REV. G
B70965
MATERIAL: CAST IRON ALLOY A-535.2

PO Total: \$887.50

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Change Nbr:

1

Change Date: 6/20/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

8657-132ND STREET
SURREY, B.C. V3W 4P1

Tel: (604) 596-8080

Fax: (604) 596-8045

Sold To: DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

Ship To: DART AEROSPACE

Comments

Castings&Patterns are property of Alpine until paid in full

PACKING SLIP

BECK ALUMINUM LEBANON

Division of Beck Aluminum Alloys LTD

24 KEYSTONE DRIVE

LEBANON, PA 17042

Telephone: 717/277-0300

Fax: 717/277-0310

3131168

Ship Date 03/04/11

Sold To:

RYPAC ALUMINUM RECYCLING LTD.
11849 TANNERY RD.
SURREY, BC V3V 3W8
CANADA

Ship To:

RYPAC ALUMINUM RECYCLING LTD.
11849 TANNERY RD.
SURREY, BC V3V 3W8
CANADA

CHEMICAL ANALYSIS - ELEMENTS LESS THAN 0.01% MAY NOT BE REPORTED

CHEMICAL ANALYSIS - ELEMENTS LESS THAN 0.01% MAY NOT BE REPORTED															
Customer	Ship Via	F.O.B.										Terms			
RYPAL	CPU # 2236	LEBANON, PA										Net 30 Days			
Purchase Order Number												Salesperson		Order Date	Our Order Number
2491												JM		03/03/11	327043
Item Number / Item Description															
I535.2 - PRIMARY ALUMINUM INGOT															
Customer	Item Code:														
Heat #	LBS	SI	FE	CU	MN	MG	CR	NI	ZN	TI	PB	SN	SP	BB	
X34408-002	1784	0.06	0.06	0.00	0.21	7.30	0.00	0.00	0.00	0.18	0.00	0.00	0.00	0.0044	
X34408-003	1740	0.06	0.06	0.00	0.21	7.30	0.00	0.00	0.00	0.18	0.00	0.00	0.00	0.0044	
X34408-004	1856	0.06	0.06	0.00	0.21	7.30	0.00	0.00	0.00	0.18	0.00	0.00	0.00	0.0044	
X34409-020	2036	0.06	0.08	0.00	0.20	7.28	0.00	0.00	0.00	0.18	0.00	0.00	0.00	0.0044	
X34409-021	2054	0.06	0.08	0.00	0.20	7.28	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0044	
X34409-022	2050	0.06	0.08	0.00	0.20	7.28	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0044	
X34409-023	2054	0.06	0.08	0.00	0.20	7.28	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0044	
X34409-024	1998	0.06	0.08	0.00	0.20	7.28	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0044	
X34409-025	2042	0.06	0.08	0.00	0.20	7.28	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0044	
X34409-026	2050	0.06	0.08	0.00	0.20	7.28	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0044	
X34409-027	2024	0.06	0.08	0.00	0.20	7.28	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0044	
X34409-028	2030	0.06	0.08	0.00	0.20	7.28	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0044	
X34409-029	1948	0.06	0.08	0.00	0.20	7.28	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0044	
X34409-030	2010	0.06	0.08	0.00	0.20	7.28	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0044	
X34409-031	2036	0.06	0.08	0.00	0.20	7.28	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0044	
X34409-032	2158	0.06	0.08	0.00	0.20	7.28	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0044	
X34409-033	2118	0.06	0.08	0.00	0.20	7.28	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0044	
X34409-034	2060	0.06	0.08	0.00	0.20	7.28	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0044	
X34409-035	2036	0.06	0.08	0.00	0.20	7.28	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0044	
X34409-038	2120	0.06	0.08	0.00	0.20	7.28	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0044	
X34409-039	2046	0.06	0.08	0.00	0.20	7.28	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0044	
X34409-040	2106	0.06	0.08	0.00	0.20	7.28	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.0044	
Weighted Avg.		0.060	0.078	0.000	0.201	7.282	0.000	0.000	0.000	0.189	0.000	0.000	0.000	0.0044	

ACCEPTABLE
PER ATLAS
FAX/SPEC
SHEET.
K07.11

Special Requirements: INVOICE, PACKING LIST AND COA FAXED OR EMAILED ASAP.

Delivery Information: CPU, Van

Total 44356

CAUTION: INGOTS ARE SUBJECT TO THE FORMATION OF SHRINKAGE CAVITIES WHICH MAY ENTRAP MOISTURE: SUCH MOISTURE CAN CAUSE AN EXPLOSION HAZARD. TO MINIMIZE THIS HAZARD, ALL INGOTS MUST BE THOROUGHLY DRIED TO REMOVE ANY ENTRAPPED MOISTURE BEFORE CHARGING THEM INTO MOLTEN METAL

Authorized Signature

Date

Trialco Inc.
900 E. 14th Street
Chicago Heights, Illinois
60411-3002

Certificate of Analysis

Alloy	535.2	Heat #	E1A2
-------	-------	--------	------

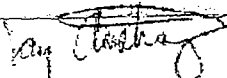
Bundle #
E1A2-040

Weight
1,878

Chemical Composition

Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Pb	Sn	Sr
0.05	0.08		0.18	7.41			0.03	0.17			
Ca	Na	Be	Bi	B	P	Cd	Sb	Zr			
		0.0040									

We certify that the above analysis is the result obtained in our laboratory for the heat indicated.



Jay Armstrong

**ALPINE NON-FERROUS FOUNDRY**8657-132nd Street,
Surrey, B.C. V3W 4P1

Tel: (604) 596-8080 Fax: (604) 596-8045

E-mail: gdhiman@telus.net**FAX COVER SHEET**

Company: DART	From: Svetq
Attn: Shantal	Date: Apr. 12, 2011
Fax Number: 613-632-1053	Phone Number: (604) 596-8080

☐ Urgent☐ Reply ASAP☐ Please comment☐ Please review☐ For your informationTotal pages, including cover: 2**Comments:**

Dear Shantal,
The description for this alloy is
535.2 - Aluminium Alloy, without
any letter. The manufacturer uses letter I
for their own identification in the
computer system.

I send to you one more material
certificate for the same material from
different supplier to show it.

If you have any question please call

Svetq,
Office Manager